

Work Order ID 54791

December 22, 2009 9:50:55 AM



Page 1

Item ID: D3656-1

Accept



Setup Start



Revision ID:

Item Name: PANEL

Stop



Start Date: 1/05/10 Start Qty: 4.00



Cust Item ID:

Required Date: 1/15/10 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D3656	Rev B								
100		0.00							
	HAND FINISHING THERMOFORMING								
Thermoform	Memo	0.00							
Thermoforming Machine	Cut Blanks to fit frame size								
110		0.00							
	THERMOFORMING MACHINE								
Thermoform	Memo	0.00							
Thermoforming Machine	Thermoform as per Dwg. D3656-1 and Folio FTA 015 using tool DT 89861 Dwg. Rev. Folio Rev.								
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	Memo	0.00							
Quality Control	Visually inspect for proper formation of each part								

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3656-1 PAR #: N/A Fault Category: ~~Alarms~~ NCR: Yes No DQA: 15 Date: 10.01.19
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: X Date: 10/01/26

NCR: 54791		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/01/07	120	Defect in the Line on former part. R.C. caused by mat. Rack. Piece of weld touched mat.	<u>10.01.07</u> <u>Q5107</u>	Scrap + Destroy + Replace Qtr & Mat <u>112176</u>	<u>BB</u> 10/01/07	<u>S</u> 10/01/15	<u>15</u> 05/01/15	<u>S</u> 10/01/15
				Fix Rack to prevent this				<u>S</u> 10/01/15

NOTE: Date & initial all entries

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Start Date: 1/05/10 Start Qty: 4.00



Cust Item ID:

Required Date: 1/15/10 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

130



QC

Quality Control

Operation
Description

QC8- Inspect parts - second check

Set Up/
Run Hours

0.00

Draw
Number

Rev.

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

=> S. Cola 15

X4

+1

140



Thermoform

Thermoforming Machine

HAND FINISHING THERMOFORMING

0.00

Memo

0.00

Trim to Finished Dimensions as per dwg D3656

150



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

Check dimensions to ensure conformity to drawing tolerances.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 54791

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Item ID: D3656-1

Accept



Setup Start



Revision ID:

Item Name: PANEL

Stop



Start Date: 1/05/10 Start Qty: 4.00



Cust Item ID:

Required Date: 1/15/10 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

160



QC

Quality Control

Operation
Description

QC5- Inspect part completeness to step on W/O

Set Up/
Run Hours

0.00

→ 510615

Draw
Number

Rev.

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170



Packaging

Packaging

Identify as per dwg & Stock Location: _____

0.00

0.00

16-1-15 40 SP

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

0.00

10/01/80 J

MF 10-1-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 1

December 22, 2009 9:50:54 AM

Work Order ID: 54791



Parent Item: D3656-1



Parent Item Name: PANEL

Start Date: 1/05/10

Required Date: 1/15/10

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MLEXS.093-F6006-07		Purchased		No		100	sf	749.8927	128.0000			

GE PLASTICS LEXAN SHEET

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	749.8926526	
107574	16.62	
111973	190.526053	
112176	542.7466	

BB
10/01/06
X4

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	34791
Description: Panel	Part Number:	D3656-1
Inspection Dwg: D3656 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Shape Definition	✓			
Free of visual flaws (bumps, cracks, voids, etc.)	✓			

Measured by: BB

Date: 10/01/07

TRIMMING SECTION

Measured by: SB

Date: 10/01/07

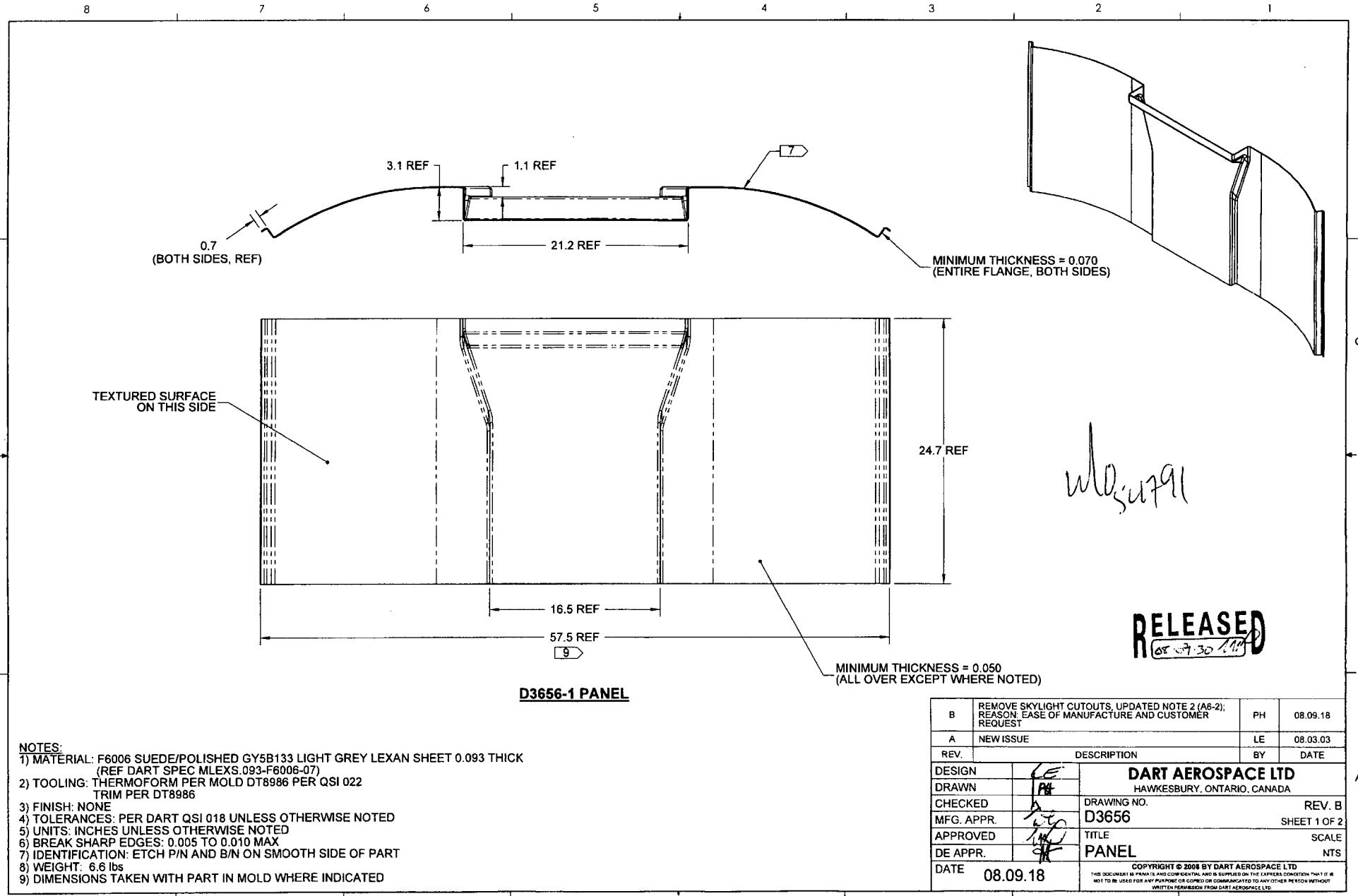
Audited by: S

Date: 10/01/15

Prototype Approval:	N/A
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Date:	N/A
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Rev	Date	Change	Revised by	Approved
A	08.05.28	New Issue	KJ/DL	
B	09.09.15	Dimensions updated per Dwg Rev B	KJ	



NOTES:

- 1) MATERIÅL: F6006 SUEDE/POLISHED GY5B133 LIGHT GREY LEXAN SHEET 0.093 THICK
(REF DART SPEC MLEXS.093-F6006-07)
- 2) TOOLING: THERMOFORM PER MOLD DT8986 PER QSI 022
TRIM PER DT8986
- 3) FINISH: NONE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: ETCH P/N AND B/N ON SMOOTH SIDE OF PART
- 8) WEIGHT: 6.6 lbs
- 9) DIMENSIONS TAKEN WITH PART IN MOLD WHERE INDICATED

B	REMOVE SKYLIGHT CUTOUTS, UPDATED NOTE 2 (A6-2); REASON: EASE OF MANUFACTURE AND CUSTOMER REQUEST		PH	08.09.18
A	NEW ISSUE		LE	08.03.03
REV.	DESCRIPTION		BY	DATE
DESIGN	<i>CE</i>	DART AEROSPACE LTD		
DRAWN	<i>PA</i>	HAWKESBURY, ONTARIO, CANADA		
CHECKED	<i>WT</i>	DRAWING NO.	REV. B	
MFG. APPR.	<i>WT</i>	D3656	SHEET 1 OF 2	
APPROVED	<i>TM</i>	TITLE	SCALE	
DE APPR.	<i>TM</i>	PANEL	NTS	
DATE	08.09.18		COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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